

Date: Tuesday, 12/08/2008 1:17:43 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ROUND SPACER
Job Number :	41179		
Estimate Number :	11299		
P.O. Number :		Part Number :	D34471
This Issue :	12/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3447 REV A
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	<u>MF 08-08-12</u>	Due Date :	19/08/2008
Comment :	Est. A05.10.19 New issue KJ/EC	Qty:	11/10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
Comment: Qty.: 0.1510 f(s)/Unit Total: 1.5099 f(s) 6061T6 TUBE Material: 6061-T6 Tubing Ø1.000 x 0.065" wall(M6061T6T1.000W.065) Identify for D3447-1 Batch: <u>M102819</u>		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Cut to length: 1.600" long as per Dwg D3447 Rev: <u>A</u> Deburr Identify as D3447-1		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
5.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 Mask inside wall		

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ROUND SPACER

Job Number: 41179

Part Number: D34471

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:45
320 °F
8:15

M-A 08/08/13 (10X)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-13 (up)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: ST

8/8/13 SG

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(11) 08/08/14

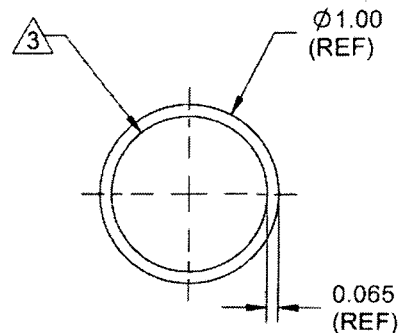
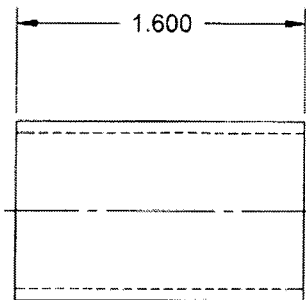
Job Completion



mf 08-08-13

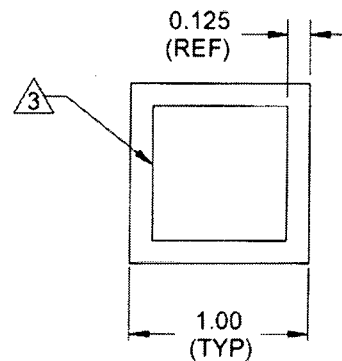
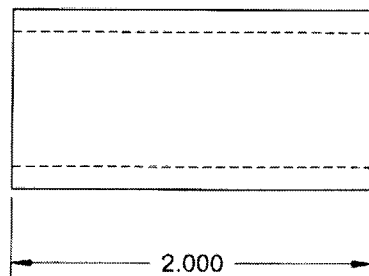


DESIGN 3	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 74	APPROVED 75	DRAWING NO. D3447	REV. A SHEET 1 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:1
A	05.07.19	NEW ISSUE	



D3447-1 ROUND SPACER

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)



D3447-3 SQUARE SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

NOTES:

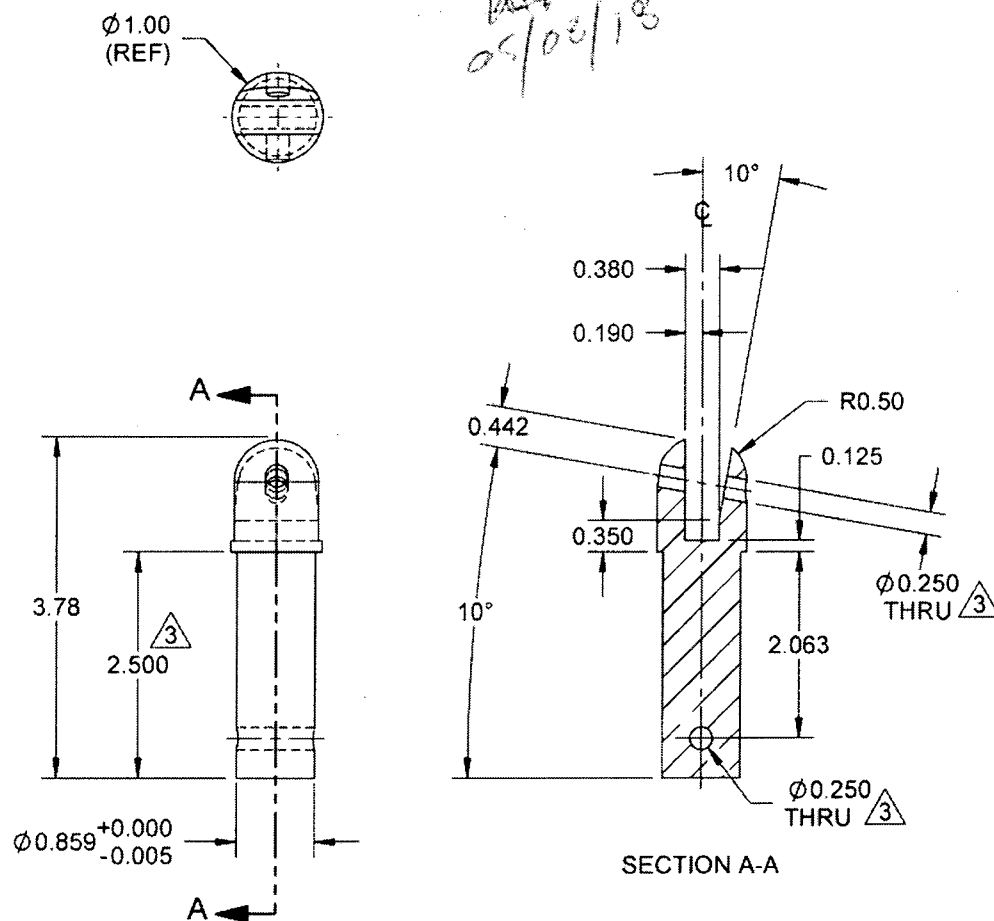
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 2 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2



D3447-5 CLEVIS

SUPERSEDES PREMIER P/N B67-43001-99

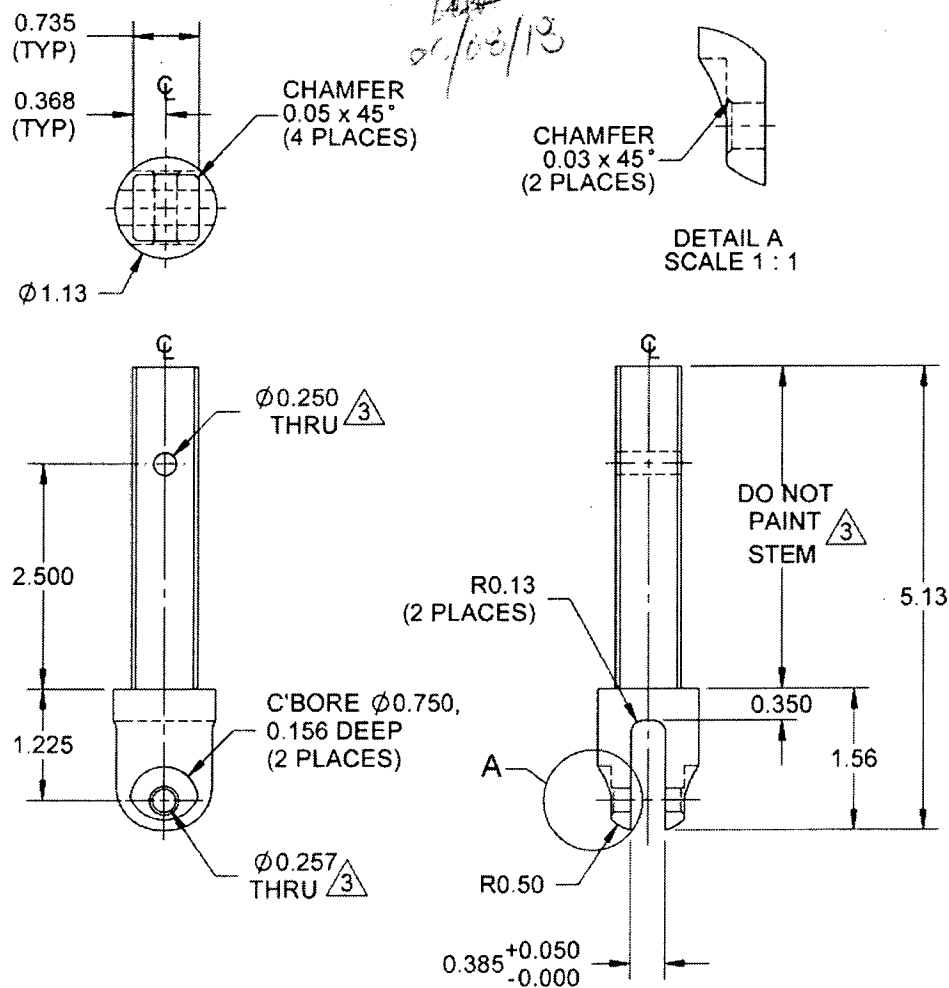
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 3 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2



D3447-7 CLEVIS
SUPERCEDES PREMIER P/N B67-43001-145/-345

NOTES:

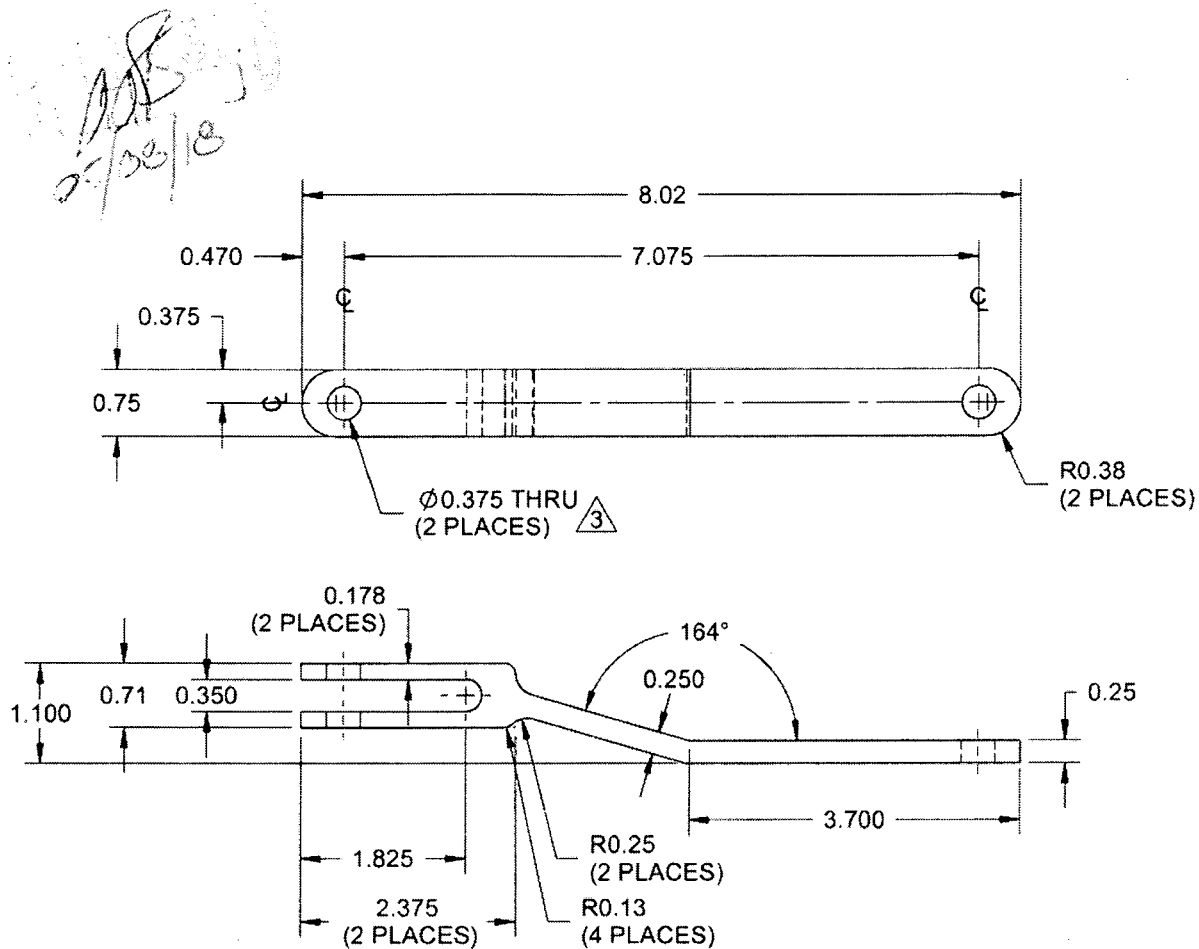
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 4 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2



D3447-9 SWING ARM
SUPERSEDES PREMIER P/N B67-43001-263

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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